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PATENT ABSTRACTS OF JAPAN

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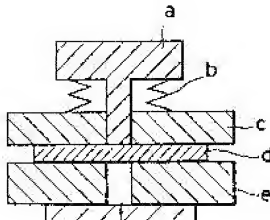
**KAWAMURA
 TOSHIO
 ENDO
 HIROHISA
 SUZUMURA
 TAKASHI**

(54) PRESS PUNCHING METHOD

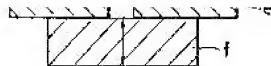
(57)Abstract:

PURPOSE: To reduce the residual strain of a formed part after it is punched and to improve its accuracy by giving a force by vibration acceleration in a punching direction for punching.

CONSTITUTION: A blank (d) is held by a die (e) and a stripper



(c) and punched by a punch (a). In this time, vibration accelerating force is synthesized by a vibrating device (f) and given to the blank



(d). One shot of punching force itself is not given to the blank (d) and forces divided into fine displacements are given at plural times to punch the blank. Consequently, the residual strain of the formed part is reduced after it is punched. The punched section is improved in accuracy, too.